





# PRODUCT DATA

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## DELTA THERM 600

### RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

#### Substrate conditions

- Steel; blast cleaned to ISO Sa 2½ or SSPC-SP-10, blasting profile 25 – 50 µm (1.0 – 2.0 mils)
  - Suitable coating (zinc silicate primer) must be dry, free from any contamination and zinc salts
  - Stainless steel; degreased and sweep blast (SSPC SP-16) cleaned to roughness of 40 – 70 µm (1.5 – 2.8 mils) with nonferrous abrasive
- Note: The maximum continuous dry heat temperature when power tool treated surface (ISO-St3) is 400°C

#### Substrate temperature and application conditions

Substrate temperature during application should be at least 3°C (5°F) above dew point

### SYSTEM SPECIFICATION

- Suitable Primers : PPG Ethyl Silicate Zinc Primers
- Do not use HI-TEMP 1027 or 222G as primer
- Direct to stainless steel with suitable surface treatment

### INSTRUCTIONS FOR USE

- Power agitate to uniform consistency
- Application with airless equipment is possible, but be careful not to apply more than specified thickness
- When applying more than one coat, it is recommended that the total dry film thickness of SIGMATHERM 540 does not exceed 80 µm (3.1 mils)

#### Air spray

#### Recommended thinner

No thinner should be added

#### Nozzle orifice

1.5 – 2.0 mm (approx. 0.060 – 0.079 in)

#### Nozzle pressure

0.3 - 0.4 MPa (approx. 3 - 4 bar; 44 - 58 p.s.i.)

The Information given above is based upon our practical knowledge and experience, but, for improvement of product, is subject to change without prior notice. Due to different materials or substrates use as well as to varying working conditions which are beyond our control, we strictly recommended to carry out trials and to consult our technicians. PT. Putramataram CI guarantees the constancy of the products.



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## DELTATHERM 600

<b>Brush/roller</b>	<b>For Roller application the best results will be obtained by using fine foam type rollers</b>
<b>Cleaning solvent</b>	<b>THINNER 21-06</b>

### ADDITIONAL DATA

#### Overcoating interval for DFT up to 25 µm (1.0 mils)

Overcoating with...	Interval	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
Itself..	Minimum	24 hours	16 hours	12 hours	6 hours
	Maximum	Unlimited	Unlimited	Unlimited	Unlimited

Note: Surface should be dry and free from any contamination

Curing time for DFT up to 25 µm (1.0 mils)	Substrate temperature	Dry to touch	Dry to handle
	10°C (50°F)	1 hour	5 hours
	20°C (68°F)	45 minutes	3.5 hours
	30°C (86°F)	30 minutes	2 hours
	40°C (104°F)	15 minutes	1 hour

### PACKAGING

<b>Packing</b>	20 kg.
<b>Storage</b>	At least 15 months when stored cool and dry

### PRECAUTION

<b>Safety</b>	<ul style="list-style-type: none"> <li>• For paint and recommended thinners see INFORMATION SHEETS 1430, 1431 and relevant Material Safety Data Sheets</li> <li>• This is a solvent-borne paint and care should be taken to avoid inhalation of spray mist or vapor, as well as contact between the wet paint and exposed skin or eyes</li> </ul>
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